

83996

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 01/05/2012 **Start Qty:** 40.00

40

Cust Item ID:

Required Date: 15/05/2012 **Req'd Qty:** 40.00

40

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: 12/05/01 Tooling:

Date:

Run Start *NR1*

QC:

Date: _____ **SPC (Y/N):** _____

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83996

May-01-12 10:36:00 AM

83996

Page 2

Item ID: D2022-103

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Spacer

Stop ***NS2***

Start Date: 01/05/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 003

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

40

40

JB 12/07/04

12/7/59

ME

12-07-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

May-01-12 10:36:04 AM

Page 1

Work Order ID: 83996

83996

Parent Item: D2022-103

D2022-103

Parent Item Name: Spacer

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A 11.05.11 new DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased	No			100	f	25.6000	0.0189	0.795789			
M6061T6R0 750									**	1.267'		12/07/04	
6061-T6 Round Bar .750"													

Location

Loc Qty

Loc Code

MAT012

11.6

120734

11.6

MAT013

14

→ 121282

14

1.267'

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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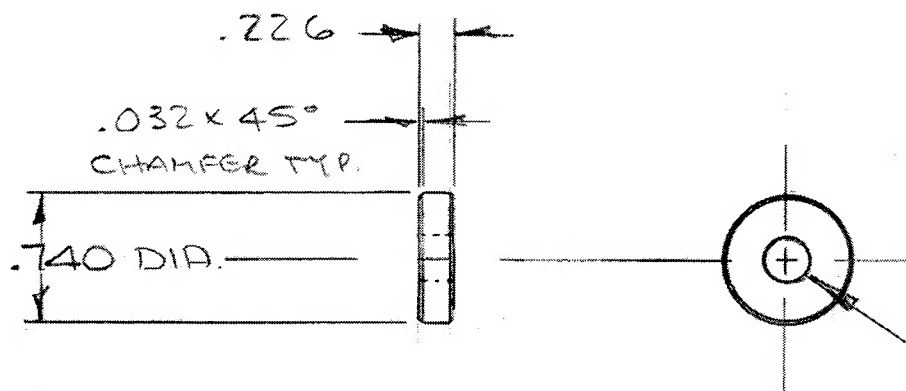
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NOTE: Date & initial all entries

RELEASED
970119 Bu

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83996 MLJ
12/05/01



DRILL 'F' (.257) DIA. IN -101
DRILL P (.323) DIA IN -103

D2022-101
D2022-103

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/B)



D2022

PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
D2022-103		SPACER 5/16	ALUM. 6061-T6	QQ-A-250/B
D2022-101		SPACER 1/4	ALUM. 6061-T6	QQ-A-250/B

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		QTY. REQUIRED	APPROVAL		CONTRACT NO.		DART AERO ACCESSORIES INC	
DRAWN			BASIC CODE	DIA. DASH NO. R-HEAD REAR SIDE T-HEAD FAR SIDE				DRAWN BRADLEY	DATE 9/10/01	CLIENT	
APPROVED			D-DIMPLE DGT-NO OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W-SPOTWELD				DESIGN BRADLEY		TITLE SPACERS	
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES				STRESS			CODE	CHG. NO. D2022
	GENERAL		LIMITS				CHECKED			REV.	
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .018 MAX 4. THREADS PER AIN - 5. 7742 5. HOLES PER AIN 10387		1. TOLERANCES — JES & .020 2. ANGLES 1. 10° 3. PARALLELISM 1. 0025 4. ECCENTRICITY 1. 003 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005				CLIENT			SCALE 1:1	SHT 1 OF 1
REPORT ALL DISCREPANCIES — DO NOT SCALE											

W/O:		WORK ORDER CHANGES					
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